

Date: Friday, 5/25/2007 8:26:18 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 32626	
Estimate Number : 10376	
P.O. Number : <i>N/A</i>	Part Number : D2885
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2885 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 29199	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/10/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature] 07.05.28</i>	
Comment : Est A 99.10.12 New Issue EC	
Est Rev:B Now 6060-T6 06-06-23 JLM	
Est Rev:C waterjet 06-07-23 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0270 sf(s)/Unit Total : 1.0794 sf(s)
 Material: 6061-T6 (QQ-A-250/8) 0.080" Thick
 Batch *m104392*

*ml 070610**(40)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2885
 Dwg Rev: *B*
 Prog Rev: *B*

*ml 070610**(40)*

2-Deburr if necessary

*GAD 07/06/23**40 counted*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*ml 070610**(40)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*ml 07/06/23**x40*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

*ml 0706-28**(40)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/06/09

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:18 AM
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Drawing Name: SADDLE SPACER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 07/06/29 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/06/29 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/29 (40)

Job Completion



CP 07/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 32626
Description: Saddle Spacer		Part Number: D2885
Inspection Dwg: D2885	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	0.425	✓		vern	
0.443	+/-0.010	0.447	✓		vern	
Ø0.257	+0.006/-0.001	0.257	✓		vern	
R0.30	+/-0.030	R0.30	✓		R-G	
0.679	+/-0.010	0.680	✓		vern	
R0.40	+/-0.030	R0.40	✓		R.G	
0.250	+0.030/-0.000	0.250	✓		vern	
0.672	+/-0.010	0.672	✓		vern	
0.521	+/-0.010	0.524	✓		High Gauge	
1.340	+/-0.010	1.342	✓		vern	
2.681	+/-0.010	2.688	✓		vern	
3.71	+/-0.030	3.71	✓		vern	
R0.38	+/-0.030	R0.38	✓		R-G	
0.528	+/-0.010	0.525	✓		High Gauge	
0.080°	+/-0.5°	0.080°	✓		A-M	

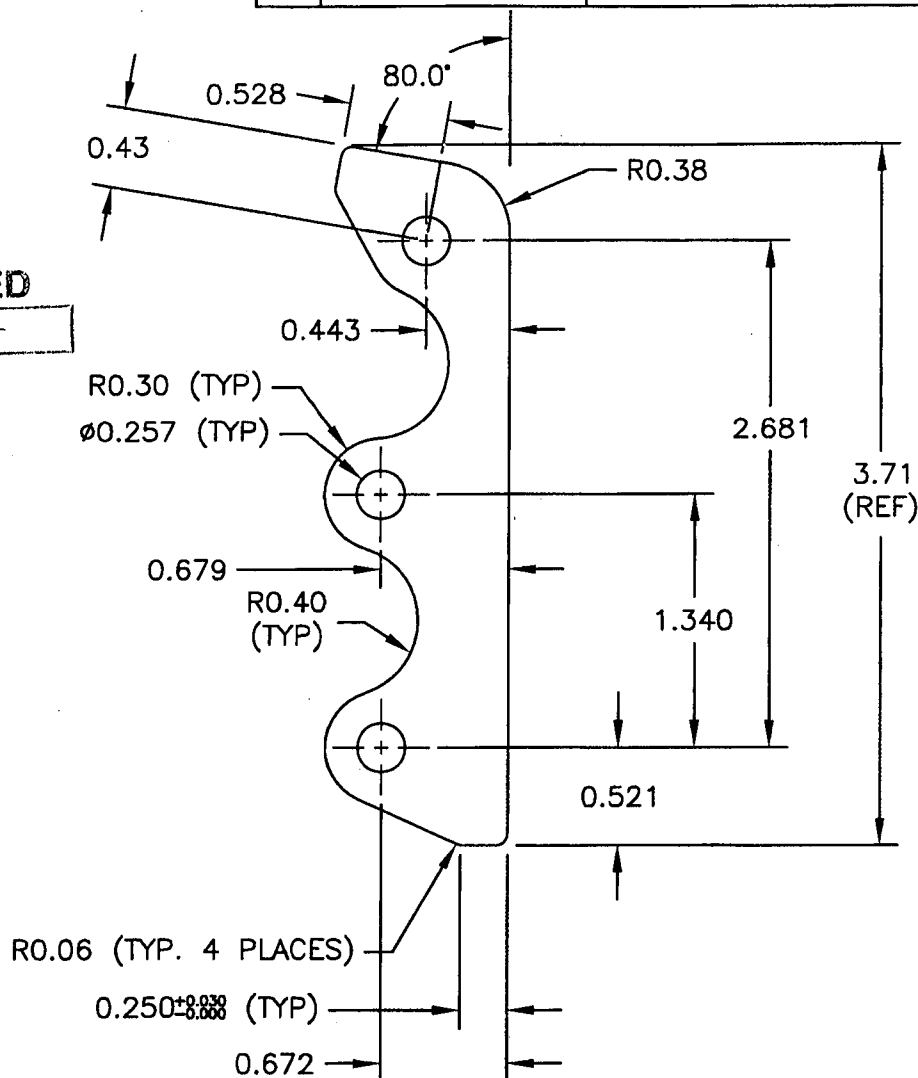
Measured by: <i>ml ml</i>	Audited by: <i>Sm</i>	Prototype Approval:	N/A
Date: 07/06/10	Date: 07/06/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SADDLE SPACER		SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED
06.06.20 *[Signature]*



NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)

- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *32626*

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